

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023397**Date Inspected:** 21-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG ASSMEBLY # BAY 14

Welding In progress -Process FCAW:

Welding of weld joint – SSDIPA-PP49-128 and 134 between Section 7AE Located on PCMK SEG No. SEG 028-001. Welder is identified as 068596. ZPMC (QC) CWI is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4-F and WPS-B-T-2231-B-U2-F.

Welding of weld joint – SEG15B-PP42-127 and SEG15B-PP42-133 between Section 6BE Located on PCMK SEG No. SEG 030. Welder is identified as 044801. ZPMC (QC) CWI is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4-F and WPS-B-T-2231-B-U2-F.

Welding of weld joint – SEGDI5-PP47-177 and SEGDI5-PP47-186 between Section 6CE Located on PCMK SEG No. SEG 030. Welder is identified as 068081. ZPMC (QC) CWI is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

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## WELDING INSPECTION REPORT

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Welding In progress -Process SMAW:

Welding of weld joint – SEG-032 13-009, 015 and 016 between section 6CE Located on PCMK SEG No. SEG 032. Welder are identified as 200114, 049339/067609/066258. ZPMC (QC) CWI is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b-FCM.

SEGMENT ASSEMBLY # BAY 19

Grinding and Welding Rectification

Noticed Grinding and Welding for Visual imperfection being rectified for BK-4A-003 and Bike Path BK-4A-006. Grinding work in progress for Transverse stiffeners.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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